

Date: Tuesday, 26/06/2007 8:43:59 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW FRAME
Job Number	: 33063		
Estimate Number	: 10624		
P.O. Number	: <i>N/A</i>	Part Number	: D2956
This Issue	: 26/06/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2956 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 33063	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 06/07/2007 Qty: 16 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A00.00.14 New issue EC Est Rev:B Now on Waterjet 07-06-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
Comment: Qty.: 3.3907 sf(s)/Unit Total : 54.2506 sf(s) 5052-H32 .040 Sheet <i>23.7349</i> Material: 5052-H34 sheet 0.040" thick. Batch <i>M102723 M102723 M101825</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2956 Dwg Rev: <i>C</i> Prog Rev: <i>C</i> <i>X15 ml 07/07/24</i> 2-Deburr if necessary <i>Y01B 07-07-22</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>B07-07-22</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>Sn 07/07/23</i> <i>(16)</i> <i>comp</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>BR / FL 07-07-30</i> <i>(16)</i>		

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW FRAME

Job Number: 33063

Part Number: D2956

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105068



(15)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/08/03

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/03 (15)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/08/03 (15)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/03

Job Completion



07.08.03

Date: Thursday, 6/21/2007 2:29:27 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW FRAME
Job Number : 33063	
Estimate Number : 10624	
P.O. Number :	Part Number : D2956
This Issue : 6/21/2007 S.O. No. :	Drawing Number : D2956 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run :	Material :
Written By : <u>                    </u>	Due Date : 7/6/2007
Checked & Approved By : <u>                    </u>	Qty: <u>16</u> Um: Each
Comment : Est. A 00.01.14 New issue EC	

Additional Product:

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 3.3907 sf(s)/Unit Total : 40.6879 sf(s)  
 5052-H32 .040 Sheet  
 Material: 5052-H34 sheet 0.040" thick.  
 Batch                     

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio FA036

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Acid etch and Alodine as per QSI 005 4.1

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 15 Date: 07/08/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/24	2	Found a Frame with a edge straight. Probability the side of the sheet	<i>[Signature]</i> 05/04/12	destroy it and no replace	<i>me</i> 07/07/24	<i>[Signature]</i> 07/07/24	<i>[Signature]</i> 05/04/12	<i>[Signature]</i> 07/07/24

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW FRAME

Job Number: 33063

Part Number: D2956

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

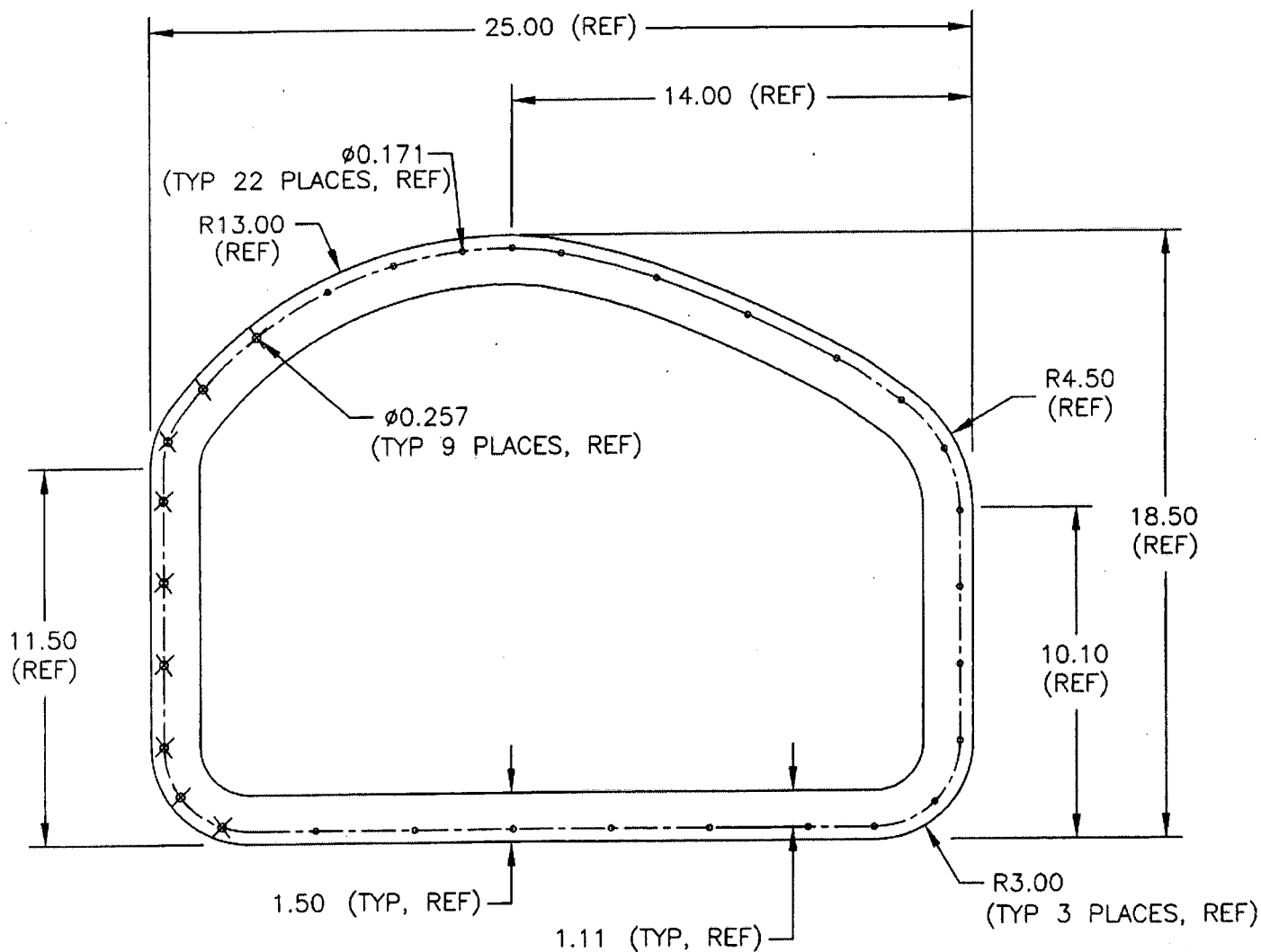
NOTE: Date & initial all entries





DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2956	REV. C SHEET 1 OF 1
DATE 01.06.04		TITLE WINDOW FRAME	SCALE 1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	Ø0.141 HOLES WERE Ø0.128 (NCR 407)	
C	01.06.04	REMOVE Ø0.141 HOLES	

RELEASED  
01.06.05



D2956 FLAT PATTERN

MACHINE PER DRAWING FILE "D2956-C1.DWG"

CHECK HOLES PER TEMPLATE DT8437

BEND PER TEMPLATE DT8567

MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK

FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 33063

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